

# Work Order ID 52689

October 7, 2009 12:50:07 PM



Page 1

Item ID: D3893-1  
Revision ID: A  
Item Name: DOUBLER

Accept



Setup Start



Stop




Start Date: 10/07/09 Start Qty: 10.00  
Required Date: 10/09/09 Req'd Qty: 10.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan:  Date:  
QC: Date:

Tooling: Date:  
SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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

Draw Nbr	Revision Nbr
D3893	REV.A

100

0.00



Waterjet  
FLOW CNC Waterjet

Memo  
1-Cut as per Dwg D3893  
Dwg Rev:   
Prog Rev:   
2- Deburr if necessary

0.00

HB 9-10-8

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC  
Quality Control

Memo

0.00

M-1 09/10/13 (25X)



HB 9-10-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52689

October 7, 2009 12:50:08 PM



Item ID: D3893-1  
Revision ID: A  
Item Name: DOUBLER

Accept



Setup Start



Stop



Start Date: 10/07/09 Start Qty: 10.00  
Required Date: 10/09/09 Req'd Qty: 10.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: Date:  
QC: Date:

Tooling: Date:  
SPC (Y/N): Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120  
  
QC  
Quality Control

QC8- Inspect parts - second check

0.00

27 S 02/10/13

count  
(425) f

Memo

0.00

130  
  
Packaging  
Packaging

Identify as per dwg & Stock Location: <sup>136</sup>~~237A~~

0.00

Memo

0.00

140  
  
QC  
Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

P 09/10/13

09/10/14 HJ

09-10-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 52689

Parent Item: D3893-1RevA

Parent Item Name: DOUBLER

Comments:

Start Date: 10/07/09

Required Date: 10/09/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S26GA		Purchased	No			100	sf	90.9358	0.1790	5000		



304/316 0.018 SHEET

18 9-10-8

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	90.9358	
105591	0.39	
107021	1.21	
108415	3.19	
109398	86.1458	

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
109398

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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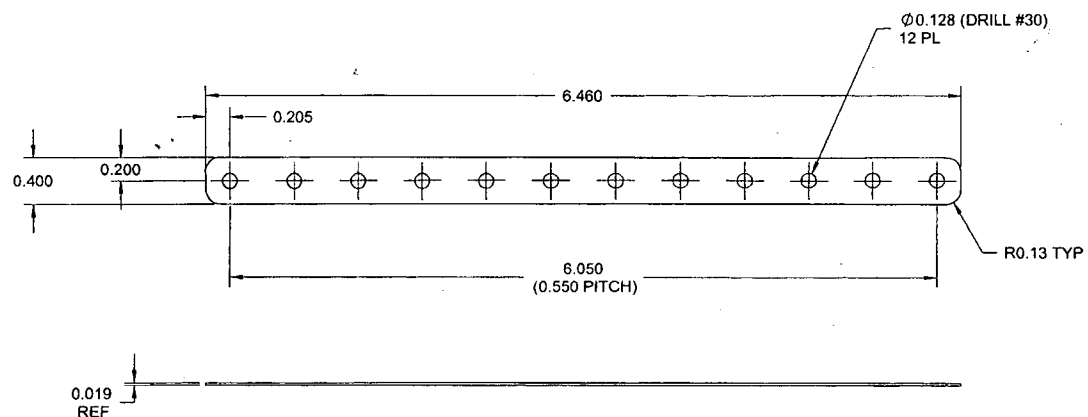
**NOTE:** Date & initial all entries



RELEASED  
09/26/23

W/O 52689

550  
130  
680



**D3893-1 DOUBLER**

**NOTES:**

- 1) MATERIAL: AISI 304 SS SHEET, 0.01875 THICK (26 GAUGE) PER MIL-S-5059 OR ASTM A240 OR ASME SA240 (REF DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3893-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

A	NEW ISSUE	CP	09.01.30
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3893	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	09.01.30	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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